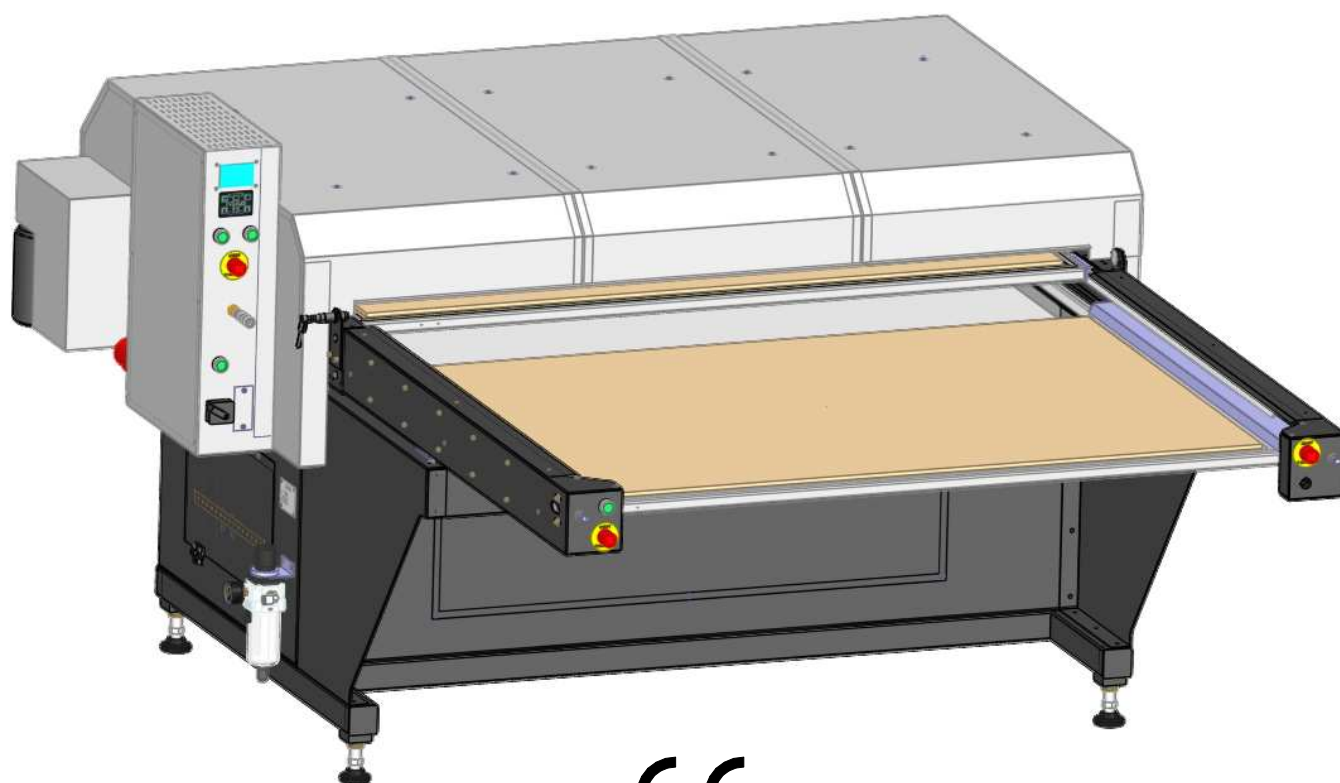


PST 1510

INSTRUCTION

MANUAL



S.E.F.A[®]

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I. GUARANTEE CONDITIONS

- The guarantee period begins on the day of commissioning on the user's premises and remains in force for two years, or 3000 hours.
- The guarantee is strictly limited to SEFA equipment and covers defects in materials and failures in performance. It is the purchaser's responsibility to show the said defects and failures.
- Our liability is limited to the commitment to repair or replace free of charge any parts recognised by SEFA as being faulty. No claims will be accepted for compensation for any reason whatsoever.
- Parts replaced under guarantee conditions:
 - Remain our property,
 - Are subject to a deposit invoice,
- A credit note cancelling this invoice will be drawn up as soon as any faulty parts have been returned. Returns must be made **ONE MONTH AT THE MOST** after the guarantee intervention.
- **THE GUARANTEE DOES NOT COVER:**
 - Perishable commercial supplies such as fuses, bulbs, transformers, seals, flexible hoses, coverings, etc.
 - As these supplies are not a part of our own manufacture, they are covered by their manufacturer's guarantee.
- **THE GUARANTEE DOES NOT APPLY:**
 - To replacements, or repairs resulting from normal wear on apparatus and machines, accidental damage due to negligence, poor servicing, poor use, or any modifications made without our written permission.
 - In the event of any defect resulting from material supplied by the purchaser, or any design may have been imposed by the purchaser.
 - To repairs resulting from damage or accidents that have occurred during transport.
 - To servicing and setting operations inherent to using the machine and indicated in the servicing instructions, such as setting intermediates, tightening piping, etc. ...



For pneumatic machines, any traces of detergent oil in the compressed air circuit inhibit the aforementioned guarantee conditions.

**For any technical information or spare parts order,
please give the machine reference and serial number.**

II. CHARACTERISTICS

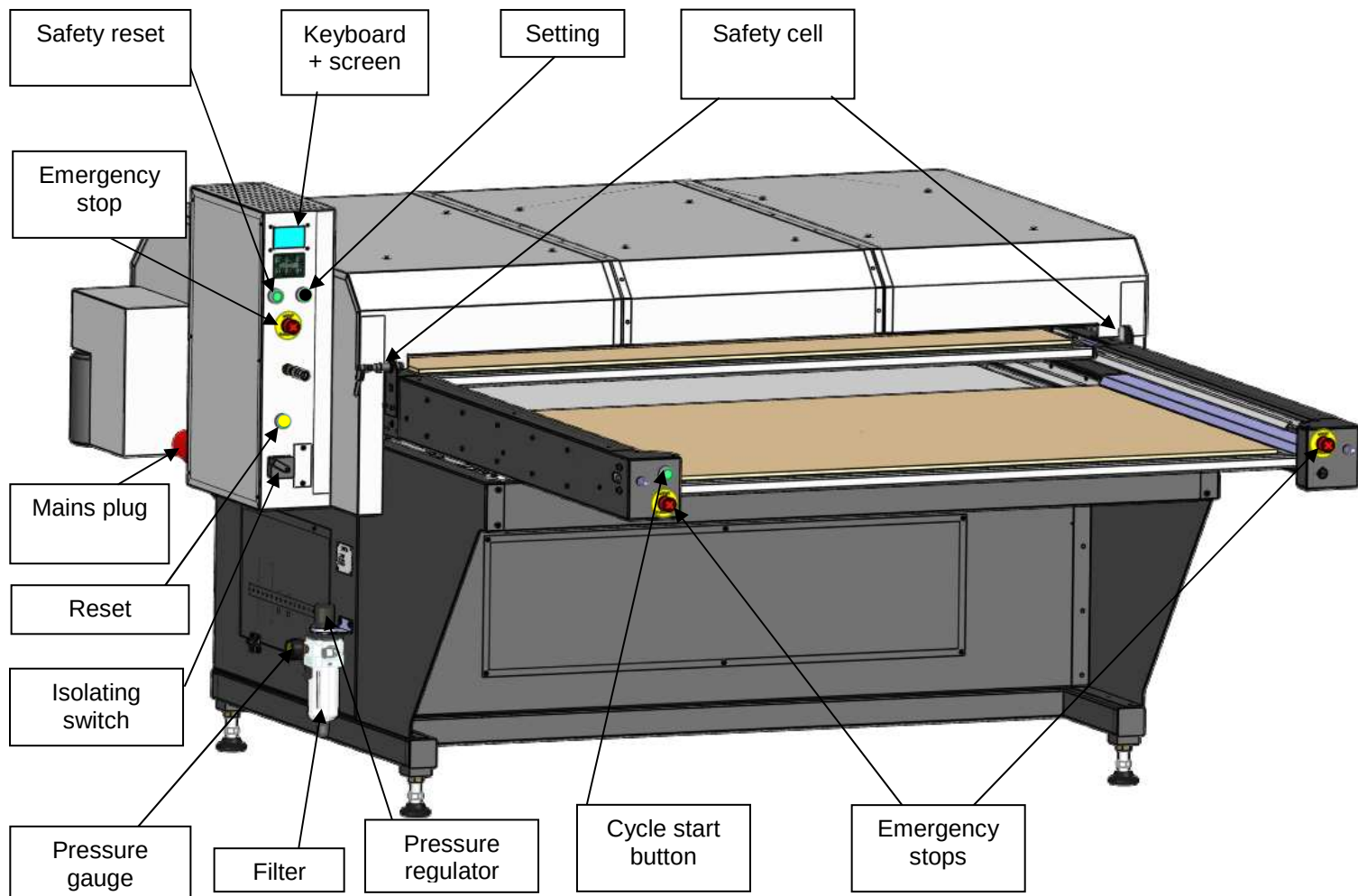
Poids en ordre de marche / Weight in running order	700kg
Hauteur / Height	1265 mm
Profondeur / Depth	2664 mm
Largeur / Width	1978 mm
Dimension du plateau / Dimension of the heating plate	1500 x 1000 mm
Alimentation électrique / Electric power supply	380 V + Neutral + earth 50/60 Hz
Puissance / Power	18.5 kW
Ampérage / Amperage	28 A
Pression de travail / Working pressure	
Min	2 bar
Max	10 bar
Régulateur électronique de température à affichage digital / Thermoregulator	
Précis à / Accurate to	+/- 1%
Réglable de / Range of control	0 to 250 °C
Minuterie électronique / Timer	
Précis à / Accurate to	+/- 2%
Réglable de / Range of control	1 to 30 min

Non-contractual document: Depending on technical evolutions, we reserve full rights to modify the characteristics of our products.

Certain of the characteristics are marked on the identification plate to be found on the machine.

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N° de Série	
Année de Fab.	
	

III. GENERAL



This thermo-printing press complies with Article L 233-5 of the labour code concerning guarantees on operator safety.

It is designed for intensive production with total reliability.

The press has been designed for use with an operator positioned at a work station opposite the machine.

IV. UTILISATION

The PST 1510 press has been designed for applying transfers of any quality in medium or large runs.
The equipment has been tested in our works for a full year's guarantee against any manufacturing defects.

Electrical, mechanical and pneumatic adjustments carried out on the machine by our technicians in our works, as well as any safety devices that may have been fitted must not be modified under any circumstances whatsoever. Otherwise, the **S.E.F.A[®]** company will refuse all liability for any possible problems related to the machine in question.

Before beginning any pressing operation, we recommend that the safety instructions and user manual be read thoroughly.

The press must only be used by an authorised person who has been informed of any risks liable to arise through incorrect use of the equipment.

1. SAFETY

THIS UNIT IS DESIGNED FOR USE BY A SINGLE OPERATOR

TO BE CARRIED OUT BY QUALIFIED PERSONNEL

International symbols:



OFF



ON



DANGER, WARNING



HOT SURFACE



RISK OF ELECTROCUTION

You will find most of these symbols on SEFA machines.

Important points for the personnel's safety:



Avoid touching any hot parts of the machine during use.



During handling operations, make sure that the operator is not subjected to any risks in terms of burns, electrocution, etc.



Inspect the machine daily before beginning production.



Make sure that there is nobody in the vicinity of the machine before starting up.



If the machine does not work correctly, disconnect the energy supply immediately, and search for the reason by referring to the "Maintenance" chapter in the manual.

Safety devices present on the machine:



***Safety devices must not be modified. They must be refitted if ever they are removed for maintenance purposes.
They must be kept in position and in good running order when the machine is in normal operation.***

The PST 1510 press is equipped with safety systems that protect the operator against any risk of parts of the body getting trapped.

The main safety elements are:

a) Emergency stop buttons

Located on the left-hand side of the machine control desk and on both arms: by activating any one of them, the machine will be switched off and the cold plate will drop down.

b) Photoelectric cell

Located at the front of the heating plate, it makes sure that the operator is away from the heating plate whilst the pressing plate is rising.

Checking safety device operation:

- A daily check should be made to ensure that the different safety devices are in correct working order.

2. INSTALLATION

TO BE CARRIED OUT BY QUALIFIED PERSONNEL

- Using a forklift truck remove the machine from its packing and position it in its place of operation
- Remove all elements used in packing: paper, cardboard, plastic film, wood, etc.
- Ensure that the machine is level (if necessary) by adjusting the height of the support bases.

When you have positioned the machine correctly at its place of operation:

- Connect the press electrically (380 Volt + neutral + Earth / 50 or 60 Hertz). The red plug is located on the left-hand side of the machine.
- Connect the machine to the compressed air network (min: 3 bars max: 10 bars). Connect the air supply to the filter-regulator unit

3. OPERATING CYCLE DESCRIPTION

1. Switch the machine on using the main switch located on the left-hand side of the chassis. Press the reset pushbutton (the screen lights up and shows the values preset in our works after the welcome message),
2. To begin a cycle, the carriages must necessarily be at the end of their movement. If this is not the case, see SETTING THE MACHINE.

3. Set the temperature with the keyboard (*to be defined depending on the type of transfer*),
See SETTING § 1a
4. Set the pressing time with the keyboard (*to be defined depending on the type of transfer*),
See SETTING § 1b
5. Set the pressure using the regulator on the left of the chassis (read the pressure gauge),
6. Place the article to be marked on the lower table,
7. Set the position of the transfer sheet,
8. Press on the green "Cycle start" button and keep away from the carriage,
9. The carriages will then move,
10. The cold plate rises and presses against the heating plate. This starts the timer.
11. At the end of the timer cycle, the cold plate returns to its low position.
12. Recommence the operation from stage 6 if the settings do not need to be changed (otherwise start at stage3).

During the cycle: Pressing the **OK/STOP** key stops the pressing operation and makes the pressing plate go down.
Pressing the **cycle start** pushbutton stops the pressing operation, makes the pressing plate go down and reverses the position of the carriages.

V. SETTING THE PRESS

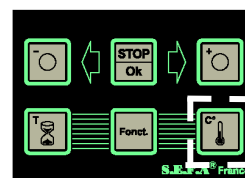
TO BE CARRIED OUT BY QUALIFIED PERSONNEL

1. TEMPERATURE / PRESSING TIME SETTINGS

These parameters must be programmed on the control system's electronic board using the keyboard located on the front (the parameters scroll down on the display unit located on the side).

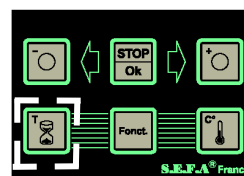
SETTING THE TEMPERATURE

- Press the "Temperature" key,
- Press the "-" key for reducing the value indicated
Or the "+" key for increasing it,
- Press the "OK" key for validating your choice.



SETTING THE TIME

- Press the "Time" key,
- Press the "-" key for reducing the value indicated
Or the "+" key for increasing it,
- Press the "OK" key for validating your choice.



2. SETTING THE MACHINE IN CYCLE START CONFIGURATION

After unpacking a new machine, or activating one of the safety devices, the following points must be validated in order to begin a cycle:

- Unlock the three emergency stop buttons (if necessary):

If an emergency stop button has been pushed in, it needs to be unlocked by turning it clockwise.

➤ Reset button:

When one of the safety devices has been activated, the machine goes into “fault” mode. It must be reset by pressing the reset button (illuminated yellow).

➤ Setting the machine

To start a cycle, the carriages must be at their end position. The carriages can be correctly positioned by pressing the black “setting” button. Keep this button pressed down until the carriages stop at their end position. Note: Movement to this position is at low speed to avoid any damage to the machine.

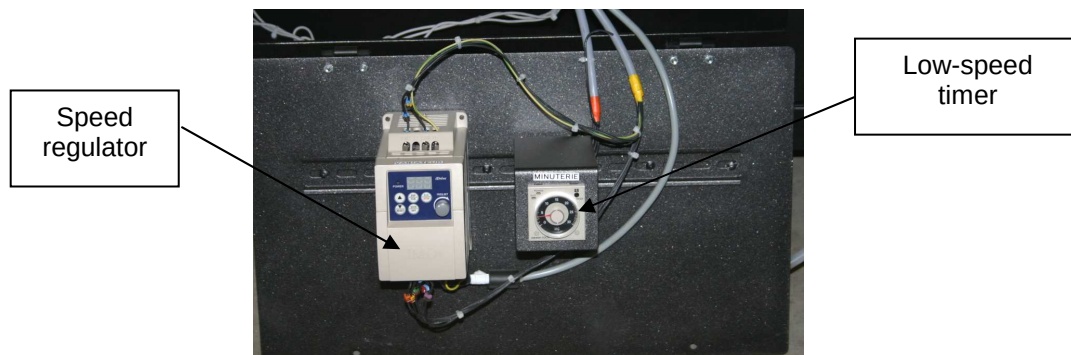
After these three points have been confirmed, the machine is in “cycle start” configuration.

3. **SETTING THE LOW SPEED TIMER**

The low speed timer is in the hatch under the control desk located to the left of the machine.

When the timer reaches the end of its cycle, the motor switches to low speed so that the carriages stop gently without moving the articles to be printed.

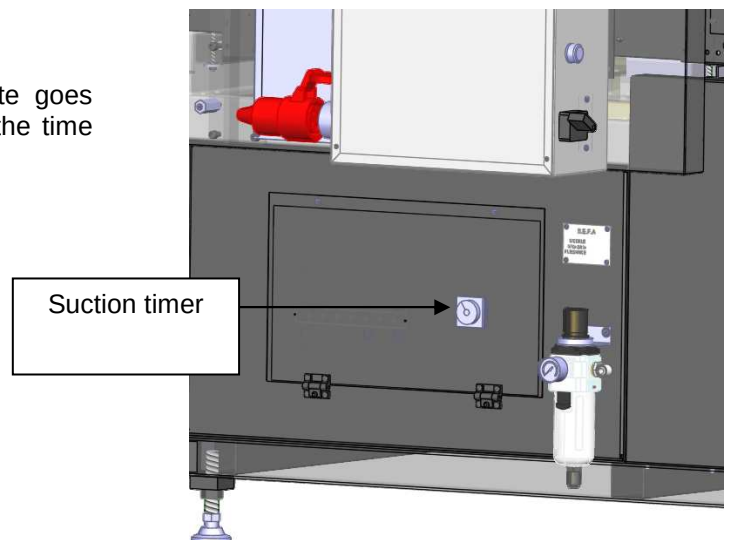
If the carriages do not slow, reduce the timer’s running time.
Setting in our works: 3.4s



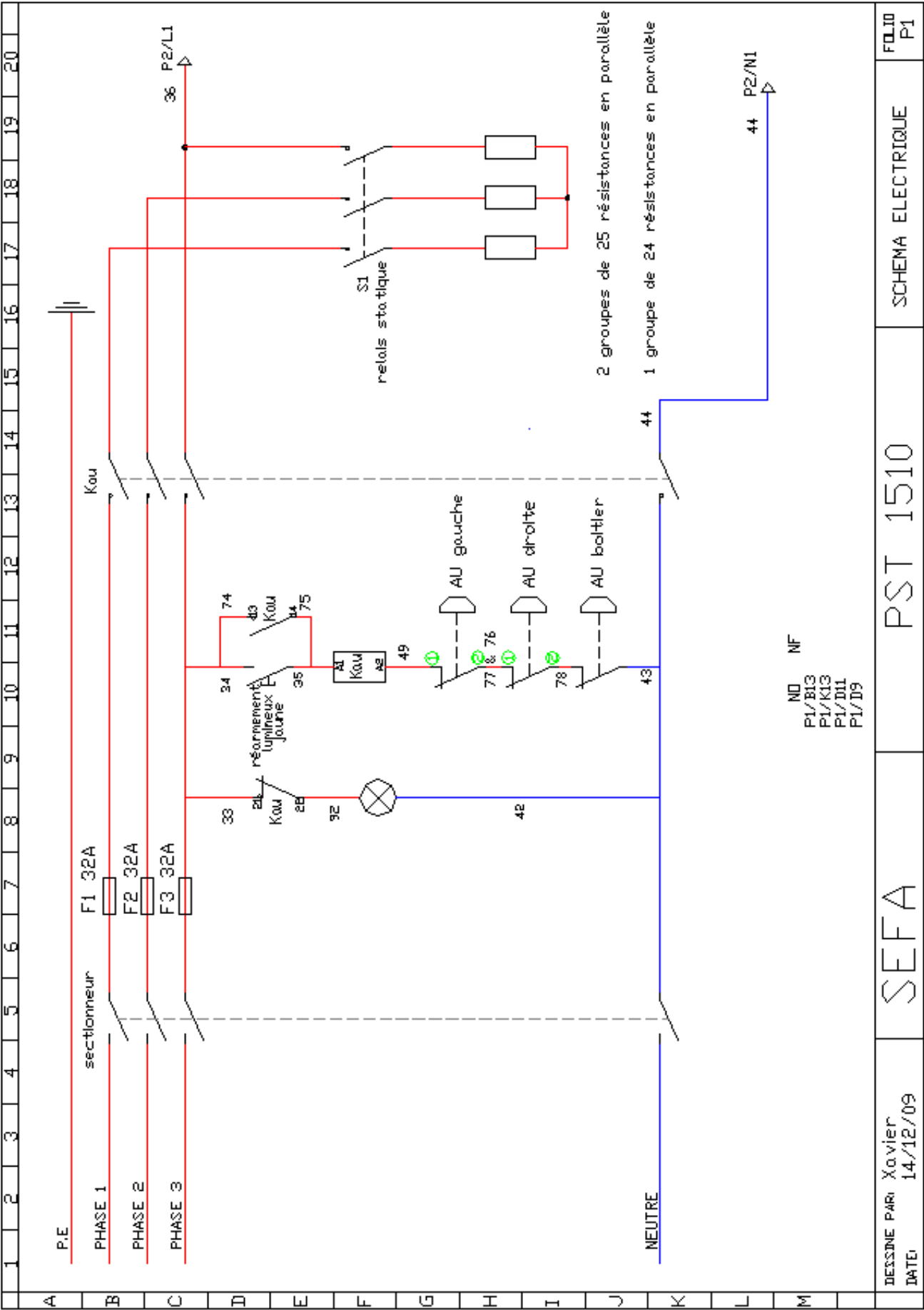
4. **SETTING THE SUCTION TIMER**

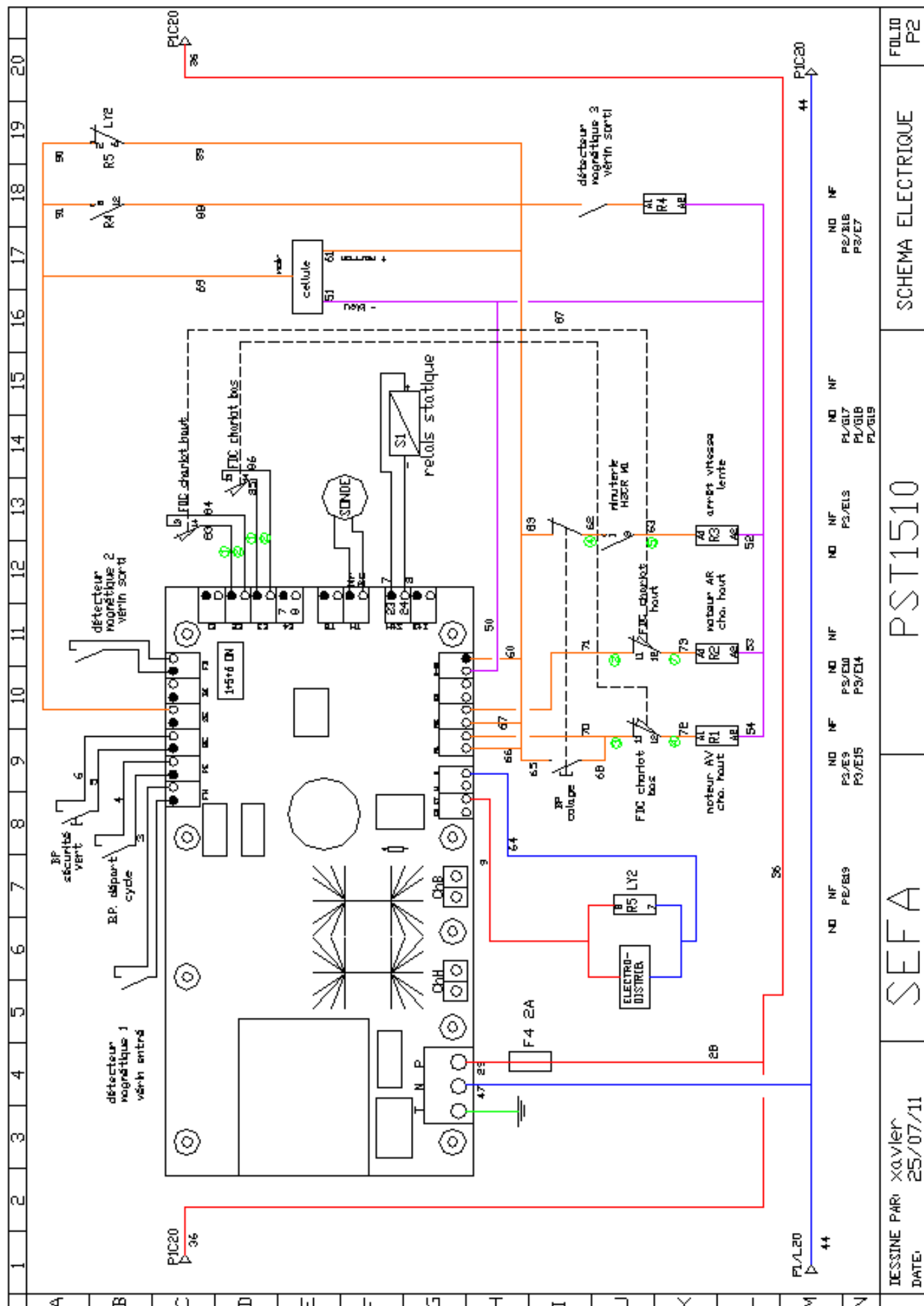
At the end of the cycle, when the pressing plate goes down, the suction ventilator is set off. It runs for the time selected on the suction timer.

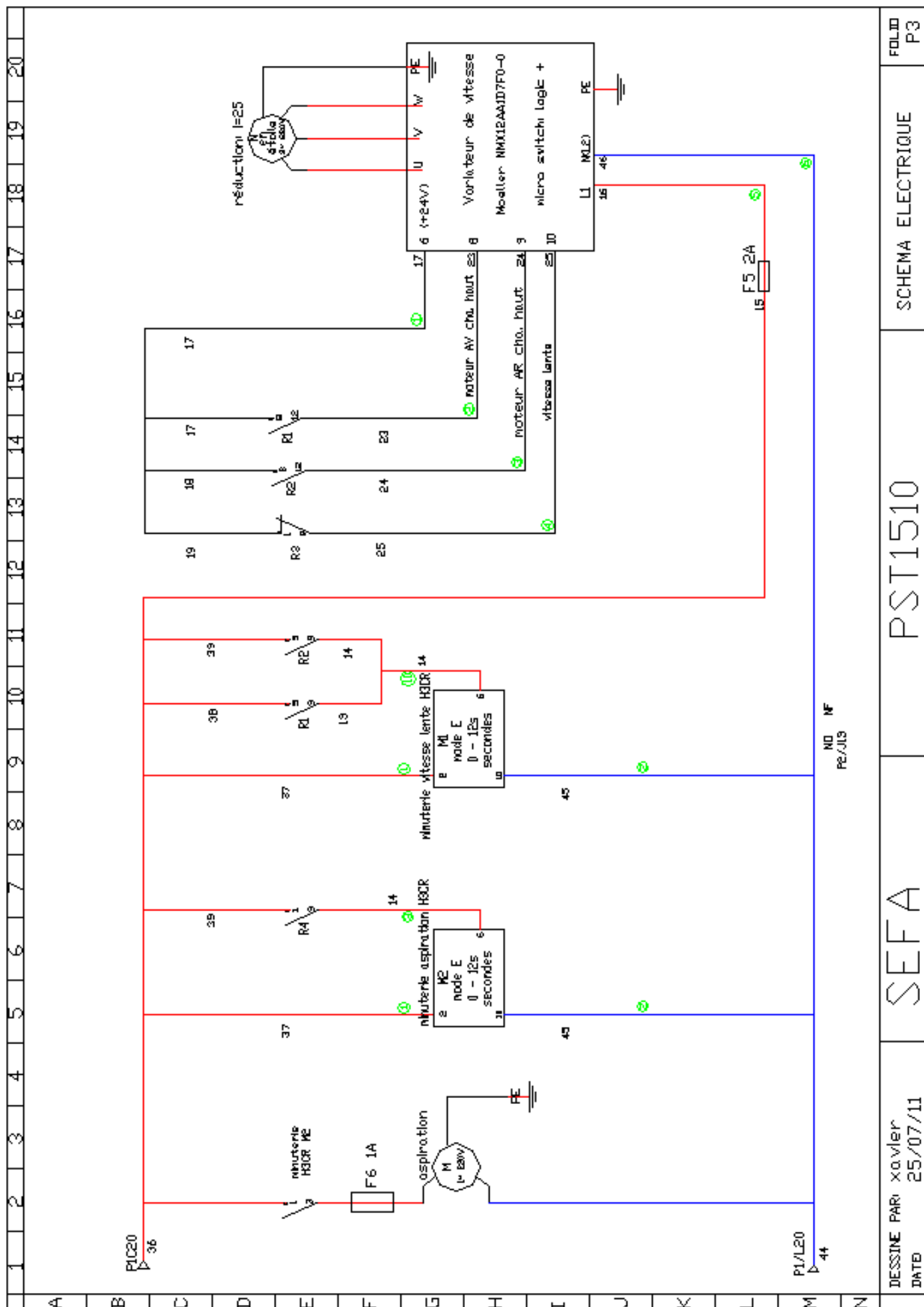
To change this time, turn the dial on the timer.



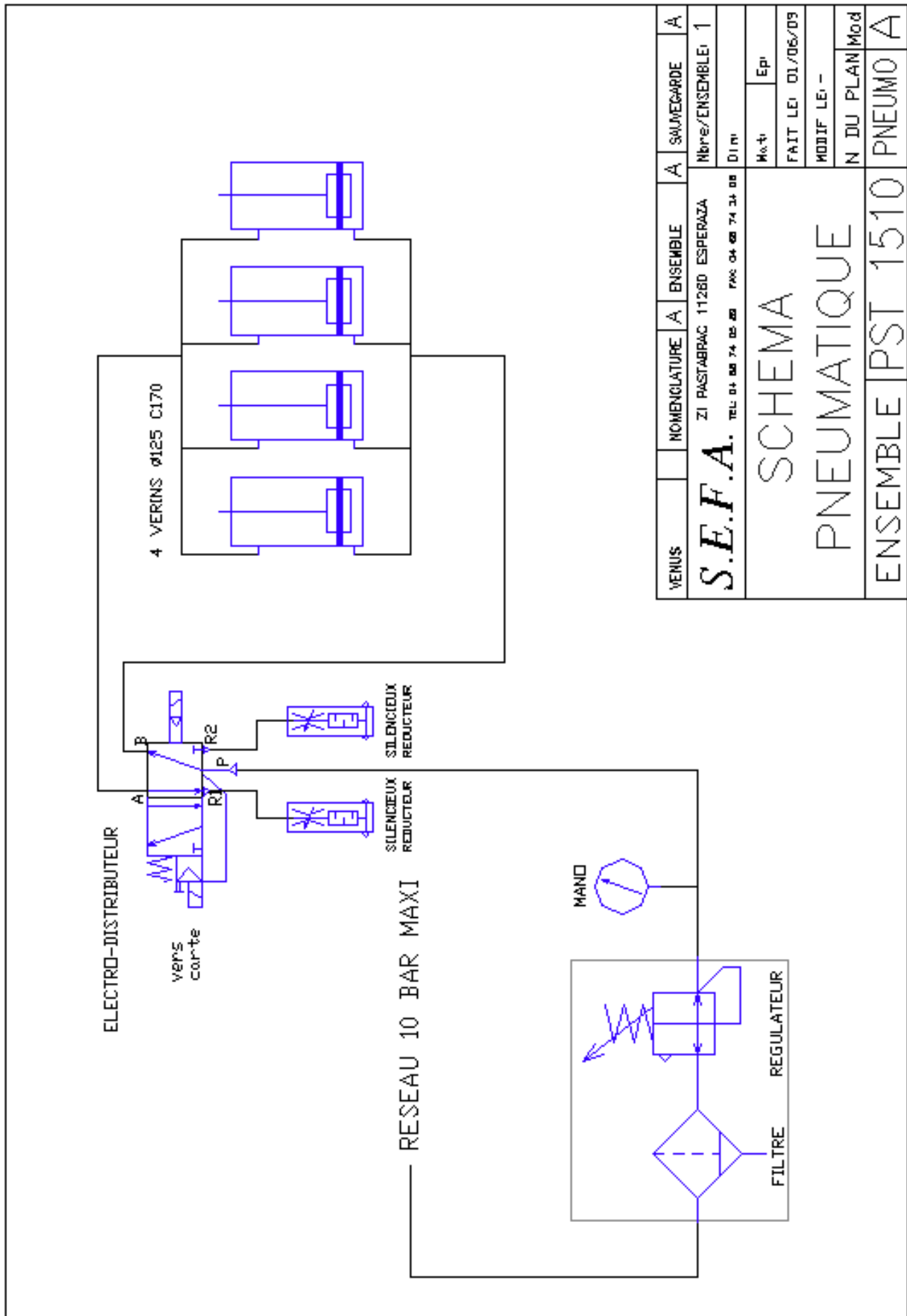
VI. WIRING DIAGRAM



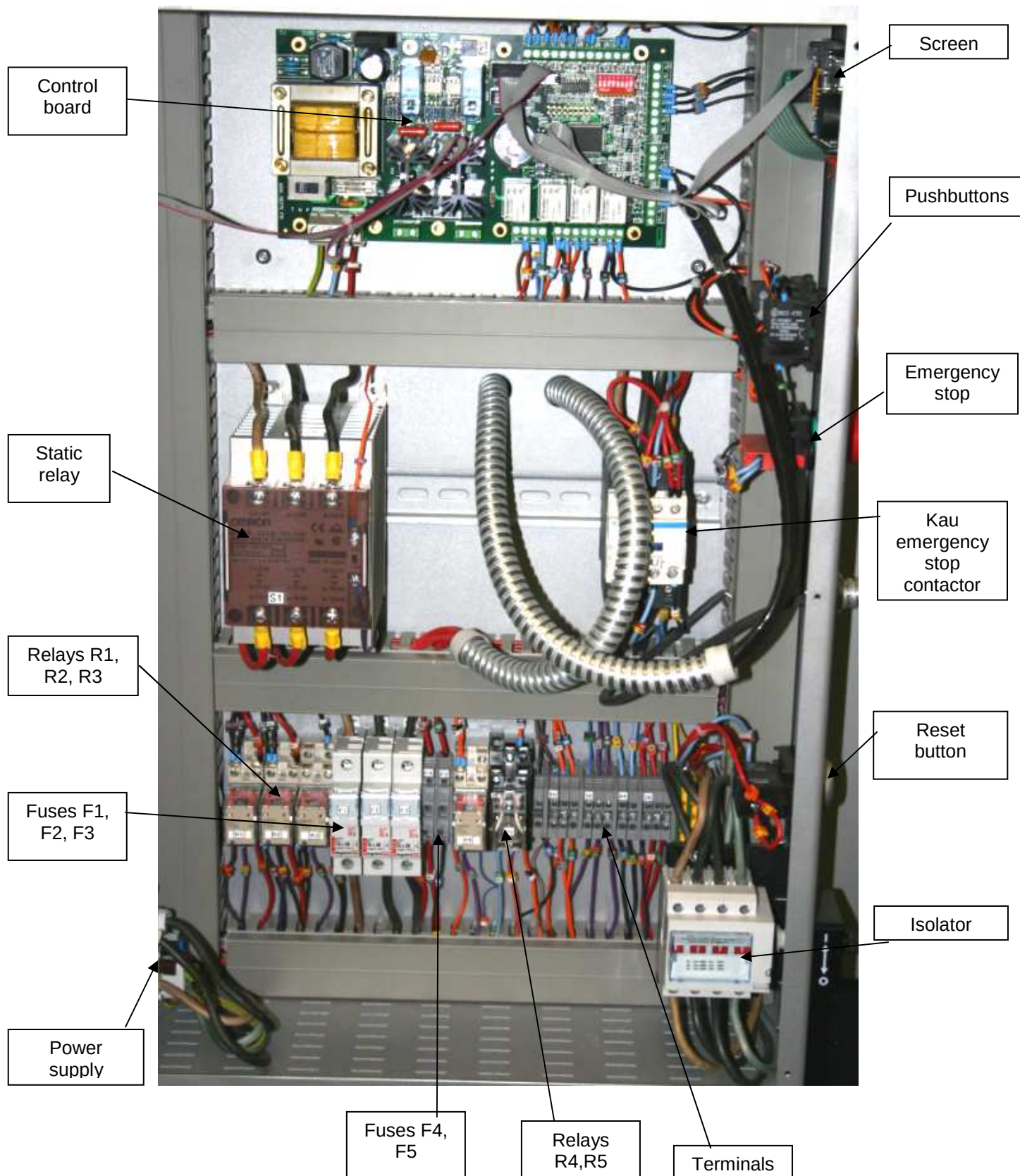




VII. PNEUMATIC DIAGRAM



VIII. CONTROL CABINET LAYOUT



IX. MAINTENANCE

TO BE CARRIED OUT BY QUALIFIED PERSONNEL

ALL MAINTENANCE INTERVENTIONS MUST BE CARRIED OUT WITH THE MACHINE AT A STANDSTILL AND ALL ENERGY SUPPLIES SWITCHED OFF (ELECTRICAL SUPPLY DISCONNECTED)

1. SERVICING

S.E.F.A[®] hot presses require practically no servicing. To check that the machine runs correctly, carry out the preventive instructions given below:

- Do not heat any objects liable to damage or even cut the felt or damage the heating plate.

DAILY: Check the air filter on the right of the machine, and empty it if it contains too much condensate.

MONTHLY: Check the shafts and lubricate if necessary.

DEPENDING ON USE: Change the felt every 6 months.

2. POSSIBLE BREAKDOWNS

ALL MAINTENANCE INTERVENTIONS MUST BE CARRIED OUT WITH THE MACHINE AT A STANDSTILL AND ALL ENERGY SUPPLIES SWITCHED OFF (ELECTRIC AND PNEUMATIC POWER SUPPLIES DISCONNECTED)

SYMPTOMS	POSSIBLE BREAKDOWNS	TROUBLE-SHOOTING
The machine will not switch on	➤ The plug is not connected ➤ The switch is not ON ➤ Fuse out of order ➤ Fuse board out of order ➤ There is a fault in the display unit	➤ Check the mains and see whether the machine is connected. ➤ Put the main On / Off switch on 1 ➤ Check the fuses in the fuse-holders located at the bottom of the control cabinet. ➤ It is located on the bottom left-hand side of the board (80mAT). ➤ Check that the cabling is connected; if this is the case, the display unit is out of order.
The plate does not heat	➤ Faulty resistances ➤ Problem with the board ➤ Temperature set too low	➤ Check the connections and the state of the electrical wiring. Contact your distributor for dismantling the heating plate ➤ See the messages displayed on the screen and refer to the manual for the board. ➤ To change this value, see the chapter on settings.
The plate is overheating	➤ Problem with the probe or the board	➤ See the messages displayed on the LCD screen and refer to the manual for the board. Contact your distributor
The timer does not work	➤ The "plate up" magnetic detector has not been actuated or is faulty. ➤ Problem with the board	➤ Check the connections ➤ See the messages displayed on the screen and refer to the manual for the board.
The cold plate does not rise	➤ A leak on the cylinders ➤ The electro-distributor is faulty ➤ Compressed air pressure is insufficient	➤ Check seals and connections. Contact your distributor ➤ Check connections Contact your distributor for changing it if necessary. ➤ Check whether the pressure on your network is less than 2 bars.
The cycle does not start The carriages do not move	➤ The carriages are not set in position correctly	➤ Press the setting button until the carriages come to a complete standstill.

3. SERVICING JOURNAL

The control and servicing operations shown in this table must be carried out regularly to check the press's condition and its reliability.

Date	Number of hours	Pressure check	Air filter check	Cylinder check	State of foam	Resistance check	Parts replaced	Remarks

To simplify completing the table, it may be useful to use the following code:

Ch: Check Cl: Cleaning R: Replacement